Owner's Manual & Safety Instructions

Save This Manual Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's serial number in the back of the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference.

CENTRAL MACHINERY®

36" METAL BRAKE with STAND

Visit our website at: http://www.harborfreight.com
Email our technical support at: productsupport@harborfreight.com

ITEM 91012

REV 14i

When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please call 1-888-866-5797 as soon as possible.

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Diagrams within this manual may not be drawn proportionally. Due to continuing improvements, actual product may differ slightly from the product described herein. Tools required for assembly and service may not be included.

⚠WARNING

Read this material before using this product. Failure to do so can result in serious injury. SAVE THIS MANUAL.

Specifications

Bending Capacity (Gauge x Width)	Up to 12 Gauge Sheet Metal at 18″ Up to 16 Gauge Sheet Metal at 36″ Up to 16 Gauge Mild Steel at 18″ Up to 20 Gauge Mild Steel at 36″ Up to 22 Gauge Stainless Steel
Bend Angles	0 to 120°
Max. Box Depth	3″
Max. Beam Lift	7/8″

IMPORTANT SAFETY INFORMATION

1. Do not exceed the maximum bending capacities of 18” wide stock (for 12 gauge steel) or 36” wide stock (for 16 gauge steel.)
2. Wear ANSI-approved safety goggles and heavy-duty work gloves during assembly.
3. Keep fingers clear of Press Plate (14) and Press Plate Assembly (17) during use.
4. Assemble only according to these instructions. Improper assembly can create hazards.
5. Place only on a flat, stable surface able to support weight of Metal Brake, item being bent, and the bending force.
6. Verify that installation surface has no hidden utility lines before drilling the holes.
7. Keep assembly and work area clean and well lit.
8. Keep bystanders out of the area during assembly and use.
9. Do not assemble when tired or when under the influence of drugs, alcohol or medication.
10. This product is not a toy. Do not allow children to play with or near this item.
11. Use as intended only.
12. Inspect before every use; do not use if parts are loose or damaged.
13. Maintain product labels and nameplates. These carry important safety information. If unreadable or missing, contact Harbor Freight Tools for a replacement.

Assembly and Installation Instructions

WARNING! The weight of the Brake and Stand requires that two people assist in the assembly and installation.

1. Place the Metal Brake (back side) on the floor with the mounting feet facing forward.
2. Place the Left Brake Stand (20) mounting pad against the left mounting foot of the Brake.
3. Assemble with Bolt (12), Washer (11), and Nut (10) as shown in Figure A. Securely tighten.
4. Mount the Right Brake Stand (19) as described in Step 2.
5. Using two people, carefully lift the Brake and Stand it upright.
6. Place the Brake and Stand in the location where it will be mounted to the floor, then mark through the 1/2 inch holes in the Left and Right Brake Stands (20 and 19).

CAUTION! Before drilling the mounting holes, verify that you will not be drilling through any utility lines or water pipes.

7. Drill four mounting holes into the floor and secure the Brake with four bolts*, lock washers, and nuts (not supplied).

*Use expansion anchor bolts for concrete floors. For wooden floors, use lag bolts.

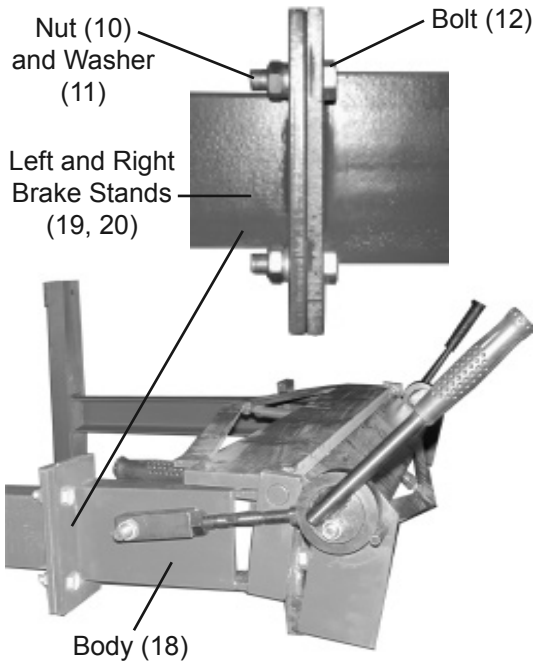


Figure A

Operation

CAUTION! Do not attempt to bend stock which is thicker than 12 gauge sheet metal. Damage could occur to the Brake. If you are not sure of the stock thickness, try bending a small piece of scrap stock. If it does not easily bend, either the stock is too thick, or the Bending Brake needs adjustment.

1. Pull the upper Eccentric Handles (2) all the way down before opening the upper Press Plate Assembly (17).
2. Scribe a line with pencil at point where stock is bent.
3. Slide sheet metal to be bent in between the Body (18) and under the Upper Press Plate Assembly (17). Align the scribed bending line with inner lip of the Body. See Figure 2, below.
4. Lift both Upper Eccentric Handles into the locked position. See Figure 2. This will cause the upper Press Plate Assembly to clamp down on the stock. If the Handle does not come down all the way and lock, the stock is greater than 12 gauge or the Brake needs to be adjusted to allow for a thicker stock. **If so, refer to the Adjustments section below.**

CAUTION! Keep spectators clear of the work area during use.

5. Using both hands, lift up on the Body using its Lower Handles until the desired angle is reached on the stock. Once bend is complete, return Lower Handles to their down position.
6. Lift the upper Eccentric Handles all the way up and remove the sheet metal.

CAUTION! During bending, keep both hands on the Lower Handles.

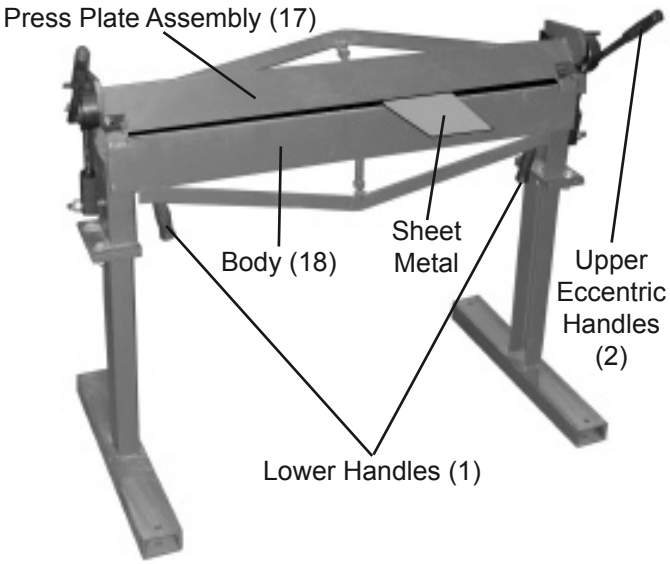


Figure B

Adjustments

Adjust the position of the Press Plate Assembly to accommodate a thicker or thinner piece of sheet metal, or to align it to the Body.

Adjusting for Thickness of Sheet Metal

1. Lift both Upper Eccentric Handles all the way up.
2. Loosen Nuts (7 and 5) to enable Bolt (6) to move up or down. See Figure 3, above.
3. Using an open end wrench, turn Bolt clockwise to lower the Press Plate Assembly, or counterclockwise to raise it up (to accommodate larger stock). Count the number of turns.
4. Adjust the Bolts with equal number of turns. The Press Plate Assembly (17) must be flush with the Body (18) when closed. If one side is not flush, readjust the side.
5. On the opposite side of the Brake, repeat steps 1 through 4.

   Adjust Bolt (6) with the same number of turns. The Press Plate Assembly (17) must be flush with the Body (18) when closed. If one side is not flush, readjust that side.

Align the Press Plate Assembly In or Out

1. Lift both Upper Eccentric Handles all the way up.
2. Loosen Bolts (16) on each side of the Brake.
3. Nudge each side of the Press Plate Assembly in or out. This adjustment will determine the roundness of the bend. The farther back the Press Plate Assembly, the rounder the bend. A typical setting should be between 1/16 to 1/8 inch behind the inner edge of the Body. The thickness of the sheet metal may also require an adjustment here.
4. Check that the Press Plate Assembly is parallel to the inner edge of the Body.
5. Retighten both Bolts.

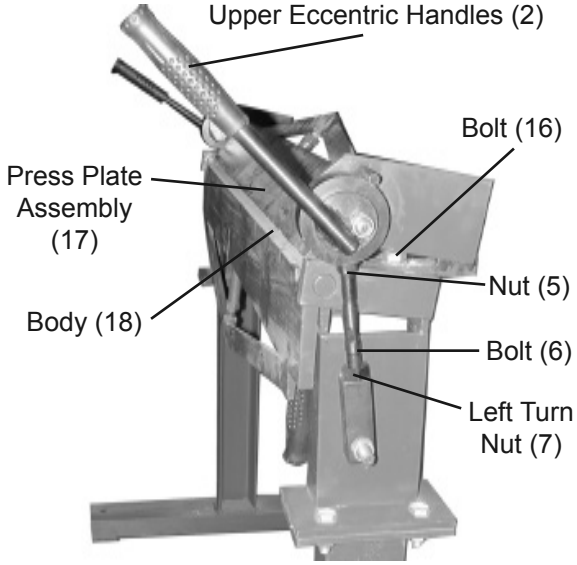


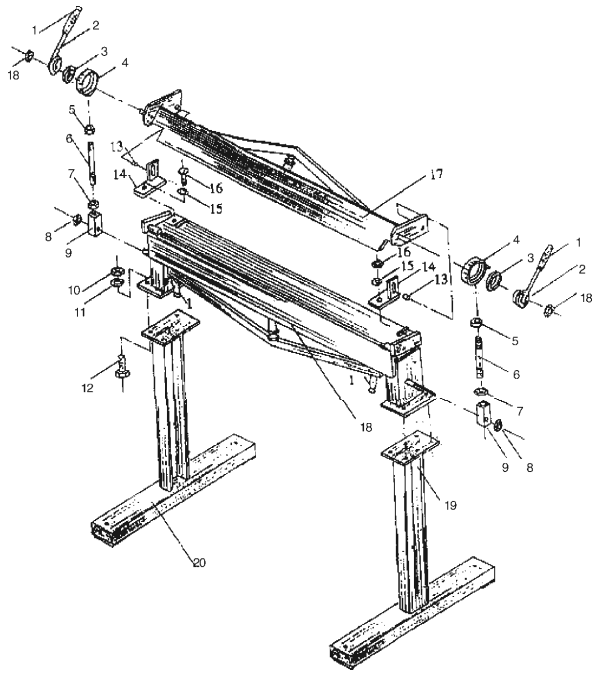
Figure C

Maintenance

1. Periodically lubricate all moving parts and surface with a light oil.
2. Cover the Metal Brake when not in use.

Parts List and Diagram

Part	Description	Qty
1	Handle	4
2	Eccentric Handle	2
3	Slide Bearing	2
4	Cover	2
5	Nut (M14 x 1.5)	2
6	Bolt	2
7	Left Turn Nut (M14 x 1.5)	4
8	Lock Nut (M12)	4
9	Square Steel Holder	2
10	Nut (M10)	6
11	Washer (M10)	6
12	Bolt (M10 x 30mm)	6
13	Copper Cover	2
14	Press Plate Bracket	2
15	Washer	2
16	Bolt (M12 x 40 / GB5783)	2
17	Press Plate Assembly	1
18	Body	1
19	Right Brake Stand	1
20	Left Brake Stand	1



Record Serial Number Here:_____

Note: If product has no serial number, record month and year of purchase instead.

Note: Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts.

PLEASE READ THE FOLLOWING CAREFULLY

THE MANUFACTURER AND/OR DISTRIBUTOR HAS PROVIDED THE PARTS LIST AND ASSEMBLY DIAGRAM IN THIS DOCUMENT AS A REFERENCE TOOL ONLY. NEITHER THE MANUFACTURER OR DISTRIBUTOR MAKES ANY REPRESENTATION OR WARRANTY OF ANY KIND TO THE BUYER THAT HE OR SHE IS QUALIFIED TO MAKE ANY REPAIRS TO THE PRODUCT, OR THAT HE OR SHE IS QUALIFIED TO REPLACE ANY PARTS OF THE PRODUCT. IN FACT, THE MANUFACTURER AND/OR DISTRIBUTOR EXPRESSLY STATES THAT ALL REPAIRS AND PARTS REPLACEMENTS SHOULD BE UNDERTAKEN BY CERTIFIED AND LICENSED TECHNICIANS, AND NOT BY THE BUYER. THE BUYER ASSUMES ALL RISK AND LIABILITY ARISING OUT OF HIS OR HER REPAIRS TO THE ORIGINAL PRODUCT OR REPLACEMENT PARTS THERETO, OR ARISING OUT OF HIS OR HER INSTALLATION OF REPLACEMENT PARTS THERETO.

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To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.